

## PRODUCT INFORMATION **3M™ SCOTCHLITE™** REFLECTIVE TRANSFER FILM **5510 SEGMENTED**

### LAMINATION ONTO SUBSTRATE

- Preheat the press.
- Material must be applied with the plastic liner. Place the transfer film with the adhesive side facing the substrate. Apply heat and pressure as described. It is not recommended to apply film over seams and stitches.
- A press-cloth or a silicone-coated slip-sheet for delicate or coated substrates may be used to cover the transfer film and substrate during lamination.
- Allow the application to cool to room temperature before removing the plastic liner. Place application on a flat surface and remove the plastic liner by lifting one corner and pulling gently at about 45° in a continuous, smooth manner.

### Substrate (Time in s | Temperature in °C | Pressure in kg/cm<sup>2</sup>):

- Knitted polyester (15 | 175 | 1.5)
- Polyester/cotton (15 | 175 | 1.5)
- 2-ply or 3-ply polyester, coated (15 | 165 | 1.5)

### NOTE:

- In general 3M™ Scotchlite™ Reflective Material – 5510 Segmented Home Wash Trim is not recommended for application on polyamide fabrics. The adhesion on polyamides such as nylon is often not satisfactory.
- Lamination on coated substrates might require reduced lamination temperature and time to prevent surface damage. Appropriate lamination parameters have to be determined accordingly. Air blisters have to be avoided.
- Substrate finishes such as silicone, paraffin, fluorocarbon resin or flame-retardant coating might strongly influence the level of adhesion to the substrate. To ensure adequate adhesion to substrate, it is strongly recommended to test the application in the intended care procedure for the finished product.

Prior to production, it is essential to test 3M™ Scotchlite™ Reflective Material 5510 on the actual substrate being used.

- Whenever two or more pieces of reflective transfer film are used together on a single surface or as a set, they should be matched to ensure uniform day time colour appearance.
- Production-dependent colour deviations of new retroreflective material do not affect the suitability of 3M™ Scotchlite™ Reflective Material for uses according to the performance requirements laid down in ISO 20471 for retroreflective material.